: CROSSBOLT SPACER

: D2743

: N/A

D2743 REV B

Date:

Friday, 31/10/2008 10:00:48 AM

User.

Julie Dawson

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 43110

Estimate Number

: 10329

P.O. Number

This Issue

Prsht Rev.

First Issue

: 31/10/2008

: NC

: 11

: 42777

Type

: MACHINED PARTS

Part Number

Drawing Name

Drawing Number

Project Number Drawing Revision

Material

Due Date : 20/11/2008

Qtv:

200 Um:

Each

Written By **Checked & Approved By**

Comment

Previous Run

: Est E 05.04.13

S.O. No. :

Reformat; removed tumble and deburr step KJ/J

LM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: 6061-T6 RD Tube .625 x.065W

1.0

56.0070 f(s)

Comment: Qty.: 0.2800 f(s)/Unit Material: 6061-T6 (WW-T-700/6)

Ø0.625 " x 0.065" wall

(M6061T6T0.625W.065) Batch:

Total:

2.0

HARDINGE



Comment: 1-TURN AS PER FOLIO FA202 & DWG D2743

FOLIO REV:

2-DEBURR AS REQUIRED



3.0

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE





4.0

QC8



Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1





Identify and Stock

Location:



Page_1

Form: rprocess

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES			.,,, ., ., .,	
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						_			
Part No	:	PAR #:	Fault Cate	egory:	NCR: Ye	es No I	DQA:	Date:	
				Disposition: C					
NCR:		,	WORK ORD	DER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Description	tion B		rification Section C	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng		ate	Section C	Chief Eng	QC Inspector
				· · · · · · · · · · · · · · · · · · ·					

NOTE: Date & initial all entries

Date: User: Friday, 31/10/2008 10:00:48 AM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 43110

Part Number: D2743

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE

8/11/1°

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aer	ospace	Ltd
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Dartho	. oopaoc								
W/O:			WO	RK ORDER CHANG	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
									
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	n:	_ QA: N/C CI	osed:		Date: _	
NCR:				ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		on B	Verification Annrol			al Approval	
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
						_			
ŀ	1								

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	131/0
Description: Cross Bolt Spacer	Part Number:	D2743
Inspection Dwg: D2743 Rev: B		Page 1 of 1

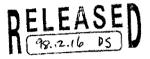
rspe	ction Dwg	g: D2743 Re	v: B				Pag	ge 1 of 1
		FIR	ST ARTICLE	INSPEC	TION CHI	ECKLIST		
			X First A	rticle	Prot	otype		
	awing ension	Tolerance	Actual Dimension	Accept	Reject	Method o		nments
. 3	.085	+0.030/-0.000	3.103			`		
Ø	0.625	+/-0.010	\$625					
0.05	0 x 45°	+/-0.010 x 45°	0.055					
0	.065	+/-0.010	0.062	/				
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eası	ured by:	DIP.	Audited b	y: \$\$	<u></u>	Prototyp	e Approval:	N/A
	Date:	08/11/14	Dat	e: 08/11	15		Date:	N/A
ev	Date	Change					Revised by	Approve
Α	04.04.20	New Issue					KJ/RF	n A
В	06.11.20	Tolerance +/-0.	010 x 45° was	U.48 x 45°			KJ/JLM	· \\ \{\\ \/_

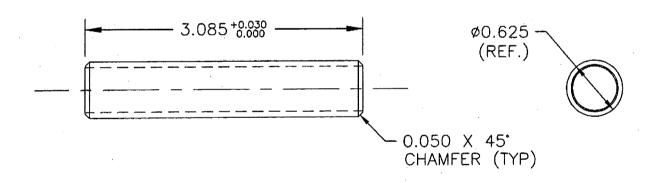
H \FORMS\Quality	Assurance\approved	QA\FAI revD





DESIG	Y} T	DRAWN BY	DART AEROSPACE	USA, INC.
77		1 a	BELLEVUE, WA	
CHECH	(ED	APPROVED	DRAWING NO.	REV. B
1	AH-	KE	D2743	SHEET 1 OF 1
DATE.			TITLE	SCALE
98.1	2.08		CROSS BOLT SPACER	1;1
Α		98.04.16	NEW ISSUE	
В		98.12.08	3.085 WAS 3.060	





MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WATOUT OF THE